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D3137-3**Job Sheet 207073****Part No:** D3137-3**Job Qty:** 24 pcs**Part Name:** Guide**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/18/20**Job Tracking No:****Due Date:** 3/6/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV F IPP Rev:A 02.05.29 New Issue NG IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC IPP
Rev c 08.07.03 ECN1207 EC verified by DD

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	24 pcs	3/6/20	3/6/20	0.00	0.29	Bandsaw - 1		ALA 20/02/29
110	HAAS 4 Axis - B4B	24 pcs	3/6/20	3/6/20	1.00	5.62	HAAS - 1 - B4B		ALA 20/02/29
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	24 pcs	3/6/20	3/6/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		OK 20/03/01
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		

**Container No:** S259577**Part:** D3137-3**Job No:** 207073**Serial No/Batch:** S259577**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 02/29/20

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			QC 8 - 76		
			QC 8 - 61		
140	Packaging 3-1 - Stock - B4B	24 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
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					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
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					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
150	QC 21 - SA	24 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS

84

9-89

5019

DAS

21

9-89

MAR 02 2020

Part Op 100 - Bandsaw - Cut Blanks. Blank size: 1.250" x .750" x .950" long
 Descriptions: 110 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA242 & Dwg D3137
 130 - QC8- Inspect parts - second check
 140 - Identify as per dwg & Stock Location:
 150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRLNB0.750X1.250	Delrin Bar	1.9008 ft (.0792 ea)	100-Bandsaw - 1	5068422

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MDELRLNB0.750X1.250	2	34	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Guide	0.175inches $\pm$ 0.010	0.185 0.165	.175"	
2	Guide	0.257inches + 0.005 - 0.004	0.262 0.256	.256"	
3	Guide	0.650inches $\pm$ 0.010	0.660 0.640	.652"	
4	Guide	100Degrees $\pm$ 0	100 100	100°	
5	Guide	0.425inches $\pm$ 0.010	0.435 0.415	.425"	
6	Guide	0.550inches $\pm$ 0.010	0.560 0.540	.550"	
7	Guide	1.100inches $\pm$ 0.010	1.110 1.090	1.101"	
8	Guide	0.470inches $\pm$ 0.010	0.480 0.460	.470"	
9	Guide	0.850inches $\pm$ 0.010	0.860 0.840	.851"	
10	Guide	0.143inches $\pm$ 0.010	0.153 0.133	.141"	

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS																																																																									
		Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐																																																																								
		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐																																																																								
		Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐																																																																								
Date: _____		Sequence #: _____		QTY Affected: _____																																																																									
Description Work Order Deviation		Disposition																																																																											
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>☐</td><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Bending</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>Crushing</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Mislabeled</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr></table>				Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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